Tuesday, 11/29/2005 7:14:45 PM

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

: 25048A

Estimate Number

: 10731

P.O. Number

: NA

: 11/29/2005

S.O. No. : NA

· NIA

: 24528A

· SMALL /MED FAB

Part Number

Material

Due Date

Drawing Name

Drawing Number

: D23243 - D2324 REV. C

: STOP

: N/A Project Number

: C **Drawing Revision** : VIA

: 12/6/2005

Qtv:

20 Um:

Each

Written By

Checked & Approved By

E 03.02.28

Reformat; Incorporated D2324-3 & D2324-5 K

J/RF

Additional Product



Seq. #:

M6061T6B0750X00750

Description:

6061-T6 Bar .75" x .75"

Comment: Qty.:

0.5565 f(s)/Unit Total: 11.1300 f(s)

6061-T6 Bar 0.75" x 0.75"

Material: 6061-T6/6511 (QQ-A-200/8) or (QQ-A-225/8) or 5052-H34 (QQ-A-225/7) or (QQ-A-250/8)

(M6061T6B0.750x00.750)

Batch: M18398 M18398

HAAS CNC VERTICAL MACHINING #1

2.0

1.0

BAND SAW

BAND SAW



Comment: BAND SAW

'Cut blanks: (0,75" x 0.75") x 5.75" Long Bar

20

3.0



1- Machine as per Folio D2324-3 and Dwg D2324

2- Deburr and Tumble to remove sharp edges

Identify as D2324-3

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

SECOND CHECK



Comment: SECOND CHECK

20

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Form: rprocess

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W/O:	2.	• 1	. 1	•		·
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W/O: WORK ORDER CHANGES							
DATE	STEP		PROCEDURE CHANGE	y Date	Qtý	Approval Chief Eng / Prod Mgr	Approval QC Inspector
•					-		
						C (\$4.7)	

Part No:	PAR #:	Fault Category:	NCR: Yes NO DQA:	Date: 05/12/16
				r
,			QA: N/C Closed:	Date:

NCR:		W			1			
DATE	STEP	Description of NC Section A			Verification Section C	Approval Chief Eng	Approval QC Inspector	
05.12.15	3	- 1 part cut too short did not machine completely	ONTHO	. scrop and replace	J.L 05.12.12	18-12-12	OFFIN	05.11.12
							**	
							:	:

NOTE: Date & initial all entries

	sday, 11/29/2005 7:14:46 PM la Lacelle	Process Sheet		
Customer:	CU-DAR001 Dart Helicopters Services	Drawing Name: STOP		1
Job Number:	~ 05040A	Part Number: D23243		
Job Number:	25046A	r dis realization.		
Seq.#:	Machine Or Operation:	Description :		
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1		
Commo	ent: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 0	05 4.1	FF 05/12/15	20
7.0	QC3	INSPECT POWDER COAT/CHEMICAL COM	NVERSION	7 -
	ent: INSPECT ALODINE PACKAGING 1	PACKAGING RESOURCE #1	28 06 W 12	100
8.0	PACKAGING	TAGINGING NESSONOL #*		
Comm	ent: PACKAGING RESOURCE #1			
	Identify and Stock Location: <u>& A</u>		SB 00/12/15	20
9.0	DC	DOCUMENT CONTROL		
Comm	Inspection Level 21	26/12/16 (20)	D oslialio	Qo
Job Completion	Inspection Level 21 Sac	05/12/16	O)lialiv	
			:	
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Form: rprocess

D	art	Aer	osp	ace	Ltd
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W/O: WORK ORDER CHANGES								
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
÷.								,
						<u>.</u>		

Part No:	3	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
		,			
				QA: N/C Closed:	Date:

NCR:				W	WORK ORDER NON-CONFORMANCE (NCR)					
:		1.	Description of NC			Corrective Action S	ection B	Verification	Approval	A
DATE	DATE STEP Section A	3 -	Initial Chief Eng	Action Description Chief Eng	n Sign & Date	Section C	Chief Eng	Approval QC Inspector		
1.7	-		: .							٠
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NOTE: Date & initial all entries

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- 7	

DART AEROSPACE LTD	Work Order:	
Description: Strut	Part Number:	D2324-3
Inspection Dwg: D2324 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

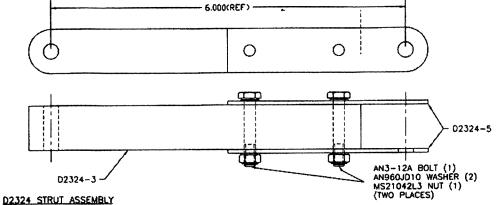
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+/-0.010	.258				
Ø0.191	+/-0.010	.193				
0.750	+/-0.010	.750				
0.375	+/-0.010	.37/				
1.875	+/-0.010	1.872				_
5.250	+/-0.010	5.245				
5.625	+/-0.010	5.621				
			,			
·						

Measured by:	J.L	Audited by:	NS	Prototype Approval:	N/A
Date:	05.12.12	Date:	05/12/12	Date:	N/A

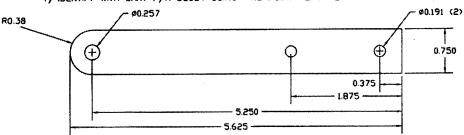
Rev	Date	Change		Revised by	Approved
Α	04.06.10	New Issue	P/O D2324-1	KJ/JLM	



DESIGN DRA		DRAWN BY	DART AEROSPACE LTD			
B WILLIAMS PH			VICTORIA INTERNATIONAL AIRPORT, CANADA			
	KED	APPROVED	DRAWING NO.	REV. C		
	#	-#-	D2324	SHEET 1 OF 1		
DATE		13	TITLE	SCALE		
04.	12.14		STRUT			
Α		94.11.08	NEW ISSUE			
В		96.05.07	UPDATE MATERIALS			
С		04.12.14	UPDATE NOTES			



1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

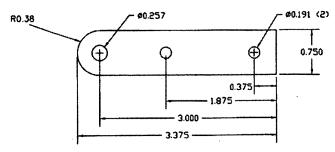


D2324-3

- 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75 1) MATERIAL:
- (REF DART SPEC. M60611680.750X00.750)

 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

 3) BREAK ALL SHAPP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED



- D2324-5

 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)

 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED